

Date: Thursday, 18/10/2007 3:26:01 PM  
User: Linda Lacelle

*ASAP DO NOT ASSEMBLE*

**Process Sheet**

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : STEP WELDMENT
<b>Job Number</b> : 34270	
<b>Estimate Number</b> : 12577	
<b>P.O. Number</b> : <i>N/A</i>	<b>Part Number</b> : D3562042
<b>This Issue</b> : 18/10/2007 <b>S.O. No.</b> : <i>N/A</i>	<b>Drawing Number</b> : D3562 UNDER REVIEW
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : 27/08/2007 <b>Type</b> : LARGE FAB ASSY	<b>Drawing Revision</b> : A
<b>Previous Run</b> : 34027	<b>Material</b> : <i>N/A</i>
<b>Written By</b> : <i>[Signature]</i>	<b>Due Date</b> : 07/09/2007 <b>Qty:</b> 6 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : <i>[Signature]</i>	
<b>Comment</b> : Est Rev A New Issue 06-11-09 JLM	

**Additional Product**

Job Number:



*P125*

<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	D2622120C	Extrusion
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Qty	Part #	Description	Batch:
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1	D2622-120C	Extrusion	<i>34694</i>
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Check Material for any Dents or Defects

*FF 07-10-31*

*(6)*

<i>2.0</i> <i>13.1</i>	D2734	206 Step Endplate
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**Comment:** Qty.: 2.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	D2734	End Cap	<i>3.34485</i>

*FF 07-10-31*

*(6)*

3.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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**Comment:** LARGE FABRICATION RESOURCE 1

1-Cut D2622 extrusion as per Dwg D3562

*FF 07-10-31*

2-Deburr and bevel ends for welding

3-Weld (1)end cap as per Dwg D3562& QSI 004. Inspect for foreign objects as per QSI 024.

A/R Aluminum Rod

4-Grind end cap welds flush as per Dwg D3562

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
07/10/08	16.0	ADD A STEP to allow the pre heating of the steps to be stable. <del>SEND CAPS</del> after welding 15 min @ 320°C to Dry off Dampers					07/10/08
07/11/12		Press Bushing D 2808 Batch B32896 in the arm.	mf	07-11-12	6		

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: STEP WELDMENT

Job Number: 34270

Part Number: D3562042

Job Number:



Seq. #:

Machine Or Operation:

Description:

4.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

2 02/11/01

6

5.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

W

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

07-11-01

6

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

02/11/01

8.0

D3560042

ARM WELDMENT



Comment: Qty.: 1.0000 Each(s)/Unit Total: 6.0000 Each(s)

ARM WELDMENT

B 34475

07-11-02

6

9.0

D3560044

ARM WELDMENT



Comment: Qty.: 1.0000 Each(s)/Unit Total: 6.0000 Each(s)

ARM WELDMENT

Batch:

B 34477 = 5

B 35032 = 1

07-11-02

6

10.0

MS20600AD4W5

Blind Rivet



Comment: Qty.: 36.0000 Each(s)/Unit Total: 216.0000 Each(s)

Blind Rivet

batch:

M 105125 = 200

M 106074 = 16

07-11-02

6

11.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Drill Rivet holes as per dwg D3562.Touch up alodine.

07-11-02

6

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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Drawing Name: STEP WELDMENT

Job Number: 34270

Part Number: D3562042

Job Number:



Seq. #:

Machine Or Operation:

Description :

Rivet legs using Magnabond as per dwg D3562.  
Ensure to wipe off any excess magnabond of the step

A/R Magnabond 6398

Batch: M104677

*07.11.02* 6

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*07/11/06* 6

13.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld Remaining end cap as per Dwg D3562& QSI 004. Inspect for foreign objects as per QSI 024.

A/R Aluminum Rod M105058

*07.11.07* 6

2-Grind end cap welds flush, as per Dwg D3562

*FF 07-11-07* 6

14.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

*PD 07-11-08* 6

15.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*07/11/08* 6

16.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

*touch up a/c line pressure wash M105194*

*07-11-09* 6

17.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Wing Walk as per Dwg D3562 and QSI 005 4.4

Batch: M106030

*07/11/12* 6

18.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*7-11-12* 6X

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Job Number:



Seq. #:

Machine Or Operation:

Description :

19.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Package as step weldments only

\*\*do not assemble\*\*

*draft TS 7/11/12 SQ 6x*

20.0

QC21

FINAL INSPECTION/W/O RELEASE



*(6)*

Comment: FINAL INSPECTION/W/O RELEASE

*20/11/14*

Job Completion



*U 87.11.13*

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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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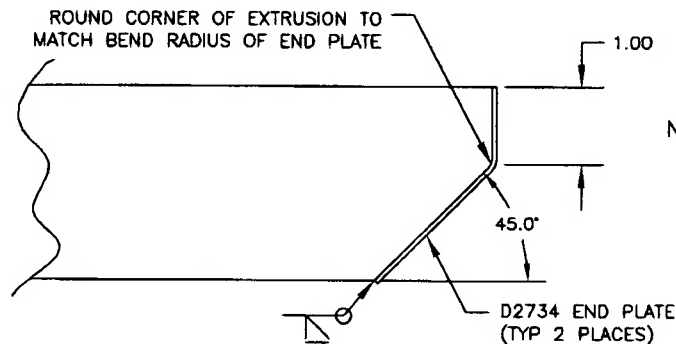
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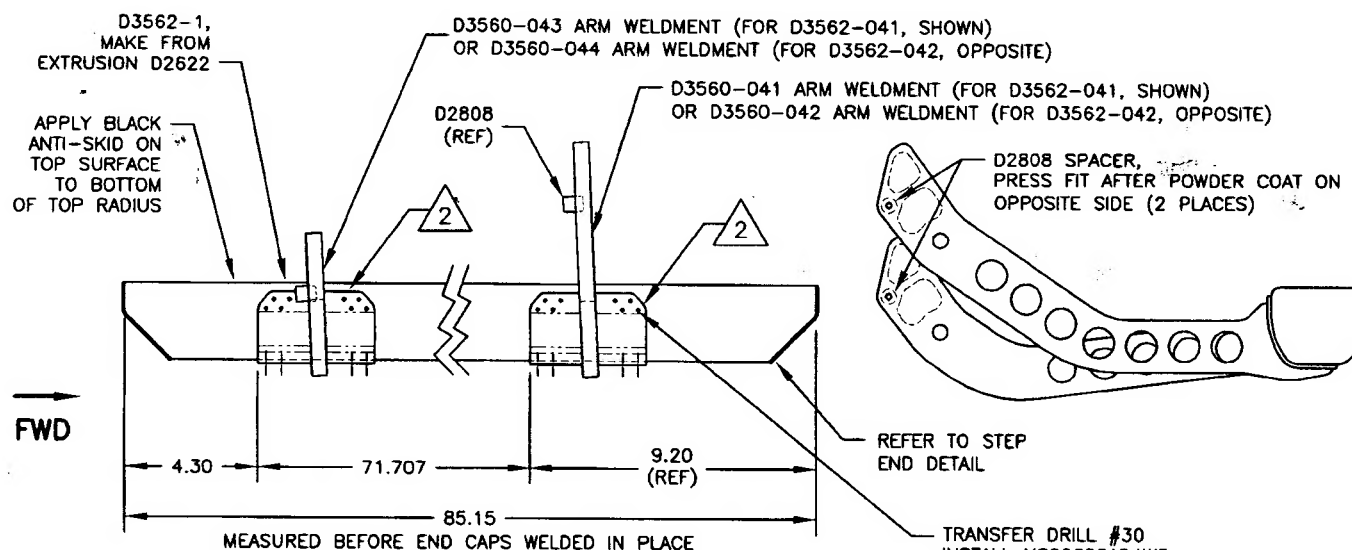


**DART****RELEASED**  
07.06.24

NOTE: ALL WELDS SHALL BE 100% VISUALLY INSPECTED BY A QUALIFIED INSPECTOR PER DART QSI 004



**TYPICAL STEP END DETAIL**  
NOT TO SCALE



**D3562-041 LH STEP ASSEMBLY (SHOWN)**  
**D3562-042 RH STEP ASSEMBLY (OPPOSITE)**

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) INSTALL ARM WELDMENTS WITH A LAYER OF MAGNOBOND 6398 BETWEEN THE ARM WELDMENT AND STEP EXTRUSION. FILL ANY TOOLING HOLES WITH MAGNOBOND 6398. CLEAN OFF EXCESS BEFORE POWDER COATING.
- 3) WELD PER DART QSI 004
- 4) FINISH:
  - i) CHEMICAL CONVERSION COAT STEP EXTRUSION PER DART QSI 005 4.1 BEFORE ASSEMBLY
  - ii) POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANDTEX (4.3.5.6) OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3. TOUCH UP ANY UNFINISHED MAGNOBOND WITH PAINT PER DART QSI 005 4.2
  - iii) BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 5) ALL DIMENSIONS ARE IN INCHES

DESIGN	DRAWN BY	DART AEROSPACE LTD
07.06.19	06.09.26	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	REV. C
DATE	TITLE	SHEET 1 OF 1
07.06.19	STEP ASSEMBLY	SCALE NTS
A	NEW ISSUE	
B	ARMS NOW RIVETED TO STEP	
C	NOW MAGBND, ADD D2808, RMV 4 RVTS	

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